

Work Order ID 83995

May-01-12 10:35:48 AM

83995

Page 1

Item ID: D2022-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 01/05/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/01 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2022	rev 97.01.14								

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Note: 257" dia drill

1-Turn as per folio FA206 & dwg

FOLIO REV: AA

DWG REV: N/A

2-Deburr as required

12/02/04 JF/ox

100 ~~100~~

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12/02/04 JF/ox

100 ~~100~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop ***NS2***

Start Date: 01/05/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: SSA 0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

100 12/07/05 100 1 SD
100x 12-7-5
12/7/6 ME 12-07-05

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Picklist Print

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Work Order ID: 83995

83995

Parent Item: D2022-101

D2022-101

Parent Item Name: Spacer

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D02.03.07 Now made in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	25.6000	0.03	3			

M6061T6R0 750

**

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code
MAT012	11.6	
120734	11.6	
MAT013	14	
→ 121282	14	

3

OK 12/07/05

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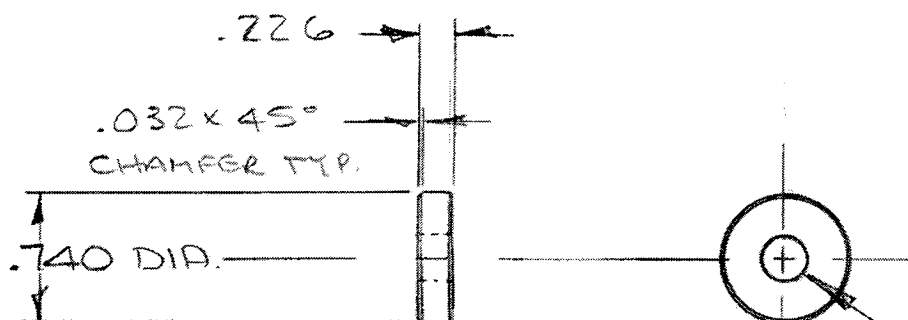
NOTE: Date & initial all entries

RELEASED
970114 BW

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 83995 MLJ

12/05/01



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L : ALUMINUM 6061-T6 (QQ-A-225/8)



D2022

D2022-103	SPACER 5/16	ALUM 6061-T6	QQ-A-250/8
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/8

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		QTY. REQUIRED	APPROVAL		CONTRACT NO.		DART AERO ACCESSORIES INC	
DRAWN			BASIC CODE			DIA. DASH NO. IN-HEAD NEAR SIDE F-HEAD FAR SIDE		DRAWN BRADLEY		DATE 12/05/01	
APPROVED			D=HOLE DASH-NO OF SHEETS C=COUNTERSINK			LENGTH DASH NO. W=SPOTWELD		DESIGN BRADLEY		CLIENT	
DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		LIMITS		BASIC CODES		SPEC.		TITLE SPACERS		REV.
	GENERAL		1. TOLERANCES - .01 & .030 2. ANGLES 1. 1/2° 3. PARALLELISM 1. .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MAT. CENTRE LINES .005		B4-M520470AD B8-M520426AD		CODE		DWG. NO. D2022		SCALE 1:1
	REPORT ALL DISCREPANCIES - DO NOT SCALE						SHT 1 OF 1				

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